

Work Order ID 85335

85335

Page 1

Date-06-12 9:17:52 AM

Item ID: D350-748-201

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/06* Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-748-241

F

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD350-748-201

CHG002

0.00

0.00

110

110

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

*****UNDER BEND 225 PER SIDE*****

250" normal

0.00

0.00

120

120

QC

Quality Control

QC QC15- Crosstube Dimensional Check

Memo

0.00

0.00

12-6-25
MLJ 12-6-25

12-6-7

P/O

12-6-25

W/O: 85335		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 350-748-101 PAR #: _____ Fault Category: X - tube NCR: Yes No DQA: Yes Date: 12/6/04
 Resolution: _____ Disposition: rework QA: N/C Closed Date: 12/7/5

NCR: 12-1553		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/04	110	Tube bent high. RC: OPERATOR ERROR	GP 12/6/04 Q1000	TRIM BOTH CUFFS TO 31.60" HIGH. Acceptable.	JW 12-6-9	Rm 12-6-11	GP 12/6/04 Q1000	120625

NOTE: Date & initial all entries

Work Order ID 85335

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Stop *NS2*

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Start Date: 06/06/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

0.00

125

HandFXtube

Hand Finishing Crosstubes

Memo

Stress relief

Heat treat crosstube as per QSI010 4.9

Temp:

Start time:

Finish time:

0.00

127

QC5- Inspect part completeness to step on W/O

0.00

127

QC

Quality Control

Memo

0.00

SEE NR
PREVIOUS PAGE

POSITIVE RECALL

EFFECTIVE 12/6/12 AUTH

RELEASED DATE

TURN DIMS 12/6/12

Pauch.

issue P/O: 40 meter

P/O: 17159

CD12/06/12

rec'd.

rec'd + inspect

attached c/c

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85335

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June-06-12 9:17:52 AM

Item ID: D350-748-201

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

JW

12-6-9

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube
Batch: _____

mo
Rm

12-6-11

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

12-6-20

POSITIVE RECALL

EFFECTIVE 12/6/11 AUTH AP

RELEASED 12/7/11 DATE 12/7/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 85335

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June-06-12 9:17:52 AM

Item ID: D350-748-201

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Outsource process-Cadplate per QSI017 4.1.9.1 0.00

150

Outsource3

Outsource process - Cad plate

Memo

Issue P/O: 17184
Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possibe Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

0.00

CZ 12/06/11 ①

160 Receive & Inspect for Damage & Mat'l Certs 0.00

160

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

★ SEE W/O CAG ATTACHED

CZ 12/06/11 ①
CZ 12/06/21 ②

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC

Quality Control

Memo

0.00

perch.

issue P/O: 17282 NDT

CZ 12/06/22 ①

see cl

attached cagc

CZ 12/06/22 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Setup Start

NS1

Revision ID:

Item Name: Crosstube Installation, High Aft

Stop

NS2

Start Date: 06/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 - 121746 start: 11:15 finish: 12:00								
	2-Paint Outside of Tube as per Dart QSI 005 4.2 - 121625 start: 4:15 finish: 5:00								
190		0.00							
190	QC14- Inspect Spray Paint								
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200		0.00							
200	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer								
	2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.								
	3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Setup Start ***NS1***

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Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	Pick Kit	0.00							
220									
Packaging	Memo	0.00							
Packaging									
230	QC4- 100% Inspect kits for completeness	0.00							
230									
QC	Memo	0.00							
Quality Control									

① 12/06/25

12/6/25

1 12.06.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85335

85335

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June-06-12 9:17:52 AM

Item ID: D350-748-201

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Installation, High Aft

Stop ***NS2***

Start Date: 06/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

0.00

240

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-748-201

Location:

PPP Rev: B

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

POSITIVE RECALL
EFFECTIVE 12/14/12 **DATE** 12/14/12
RELEASED 12/14/12
DS APPROVAL OR D.D.
DIMS.

K SP
12-6-25

MCS 12/06/12

MCS 12/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-06-12 9:17:57 AM

Page 1

Work Order ID: 85335

85335

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev: D 08-06-24 revD as per dwg DD verified by: EC
 IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by: EC IPP Rev: F
 10.08.04 added QSI010 4.3 DD verf: EC IPP REV: G ADD
 UNDER BEND COMMENT 12-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-748-241TRN

Manufactured No

110

Each

2.0000

1

1

D350-748-241TRN

Crosstube Turning Detail

**

12-6-7

Location

Loc Qty

Loc Code

LG

83289

2

61314

0

61315

0

79393

1

83287

1

ALS4-1032-225

Purchased

No

200

Each

781.0000

1

1

AI S4-1032-225

Insert

**

12 06 24

Location

Loc Qty

Loc Code

ST281

758

108696

146

110768

62

118386

55

118966

68

121269

427

ST282

23

120410

10

120451

13

118520

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

June-06-12 9:17:57 AM

Page 2

Work Order ID: 85335

85335

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

AN960.ID10

Washer

D2856-400

Manufactured No

D2856-400

Abrasion Strip

200 Each 0.0000 1 1

**

12 06 24

200 f 214.3745 1.181 1.243158

**

12 06 24

Location

Loc Qty

Loc Code

ST403 204

81875 204

ST409 10.3745

63735 0.6696

68076 0.3149

71164 8.46

79551 0.93

1- cut as per dwg D2856

D3502-1

Manufactured No

D3502-1

Support

200 Each 81.0000 2 2

**

12 06 24

Location

Loc Qty

Loc Code

LG050 60

77041 60

ST051 21

73419 11

74873 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 85335

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

85335

D350-748-201

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

200

Each

86.0000

2

2

MS21920-20

Clamp (per MIL-DTL-8783C)

**

12 00 24

Location

Loc Qty

Loc Code

LG050

86

116799

8

120676

8

121067

20

121274

50

MS27039-1-10

Purchased

No

200

Each

126.0000

1

1

MS27039-1-10

Screw

**

12 00 24

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

26

120120

26

AN4-41A

Purchased

No

220

Each

539.0000

8

8

AN4-41A

Bolt

**

12 00 24

Location

Loc Qty

Loc Code

360

181

121185

181

ST360

358

115108

3

115705

7

118451

29

118838

50

119328

100

120423

150

121205

15

121573

4

8

June-06-12 9:17:57 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 85335

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Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

220

Each

1,389.000

4

4

MS21042L5

Nut

12/06/12

Location

Loc Qty

Loc Code

300	500	
121652	500	
ST300	889	
108827	8	
116105	5	
116548	43	
117611	18	
119109	807	
<u>17651</u>	8	

Y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

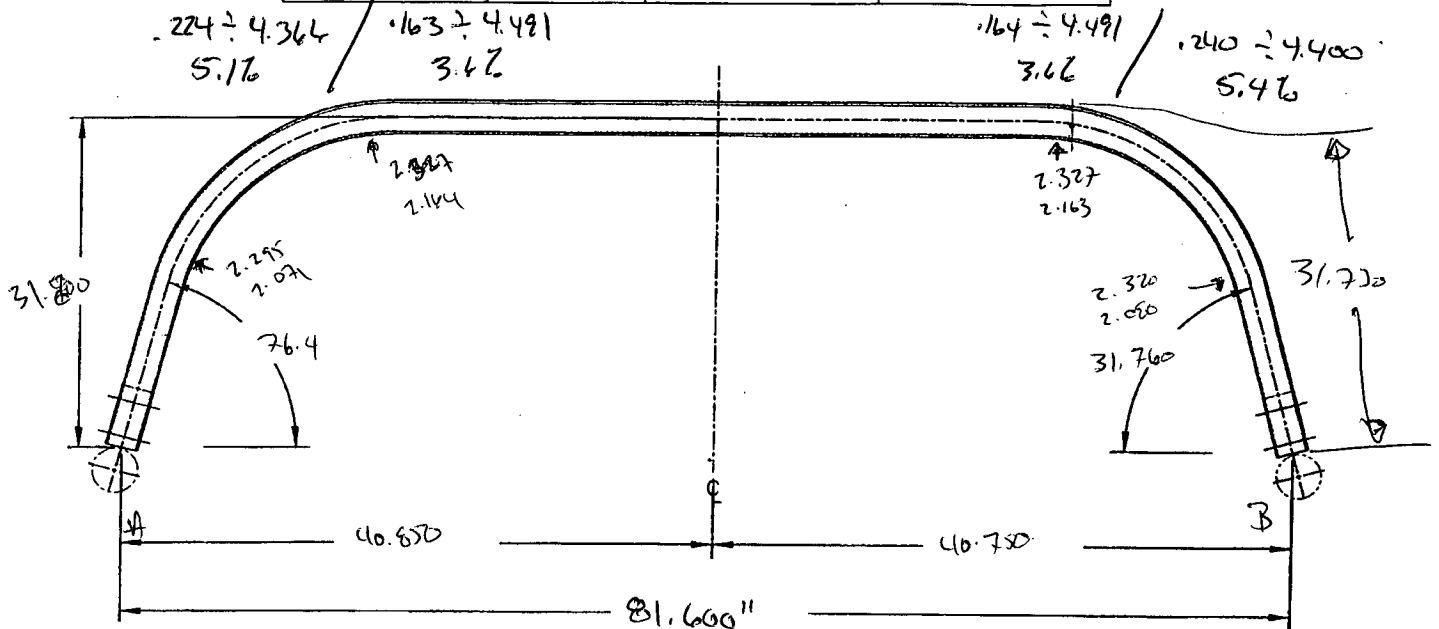
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25335
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
twist = 0.132
Side A = 5.16 at Bottom of Bend / 3.66 at top End of Bend
Side B = 5.46 @ Bottom of Bend / 3.66 at top End of Bend

QC15 Inspection	
Date	

TRIM BOTH SIDES
TO 31.60"

Acceptable
CP 12/6/9
QSI 642

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6015-125	CROSSTUBE (OR D6018-125)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER
BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT. PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85335 MJS
12/06/06

RELEASED
R 2011-07-08
W

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. F
MFG. APPR.	h	D350-748-241	SHEET 1 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

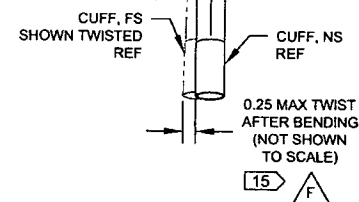
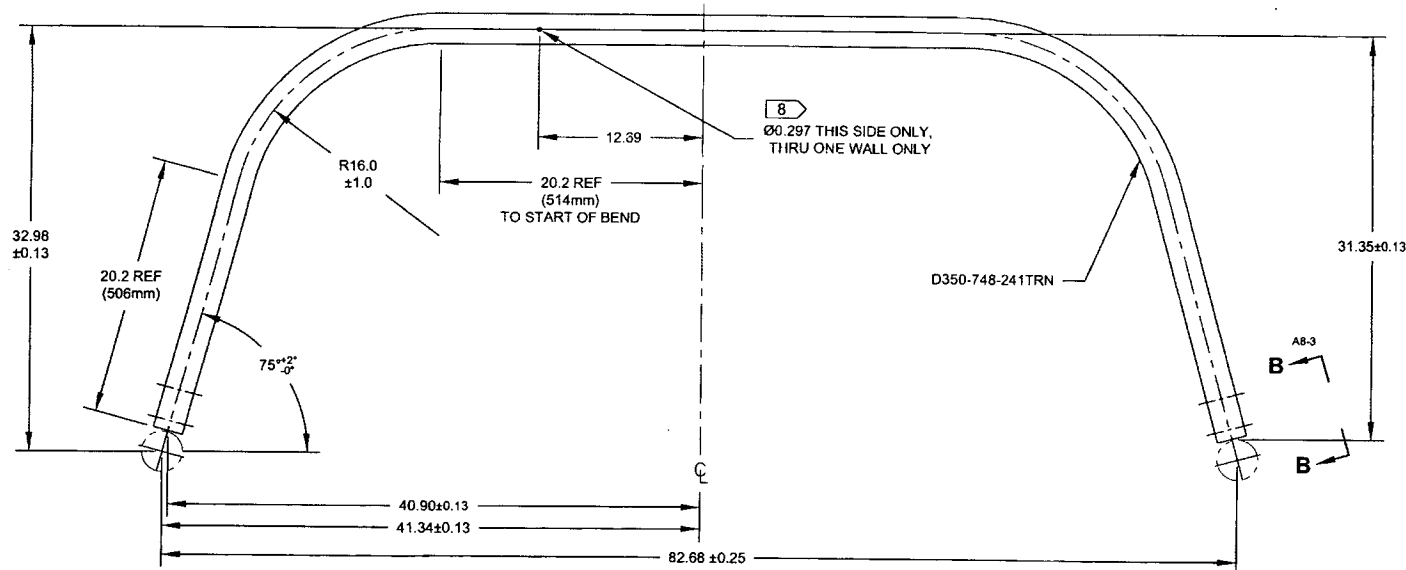
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

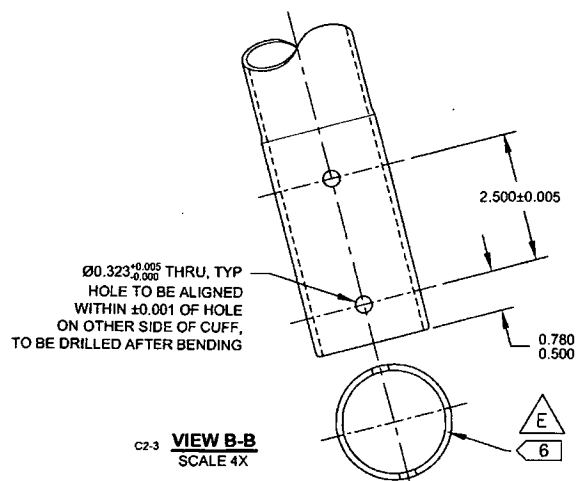
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

25335



D350-748-241
BENDING AND DRILLING DETAIL 10



RELEASED
R 2011-01-18

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>90</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>h</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>h</i>	D350-748-241	SHEET 3 OF 4
APPROVED	<i>h</i>	TITLE	SCALE
DE APPR.	<i>h</i>	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

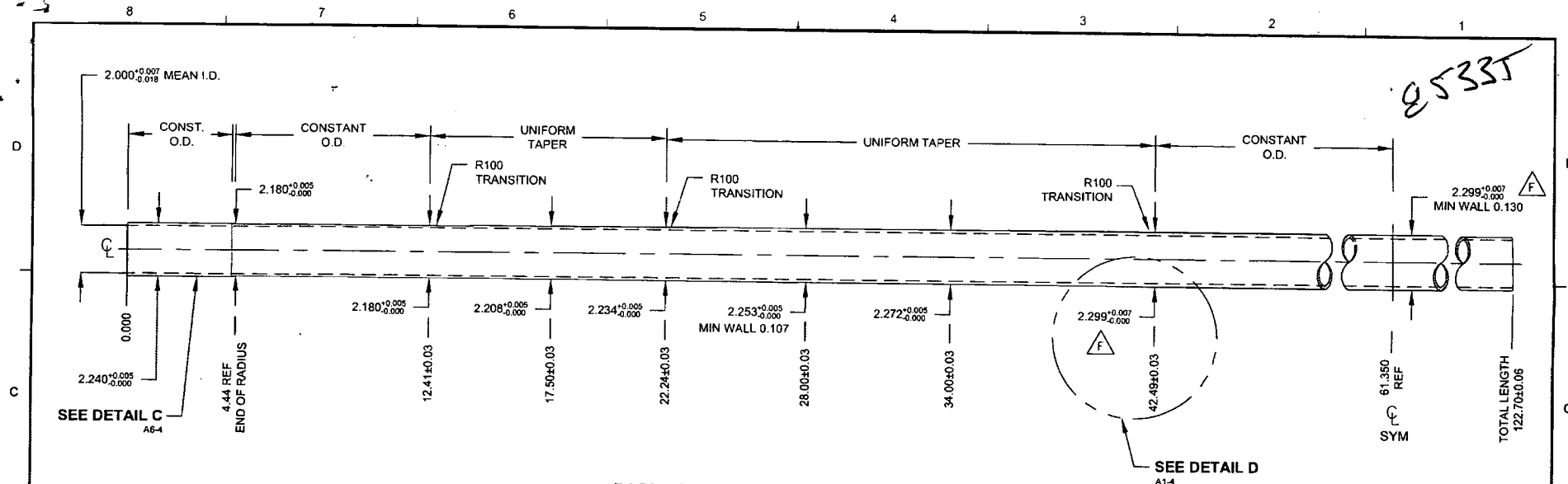
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

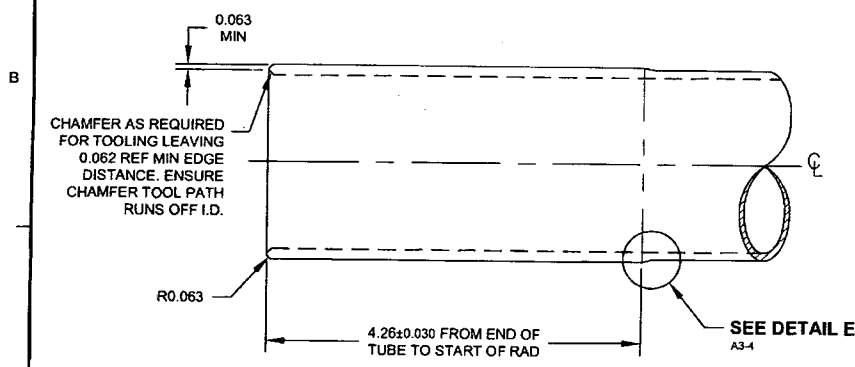
NOTE: Date & initial all entries

2533T

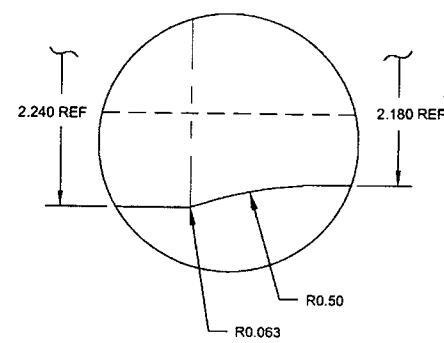


D350-748-241TRN
TURNING DETAIL

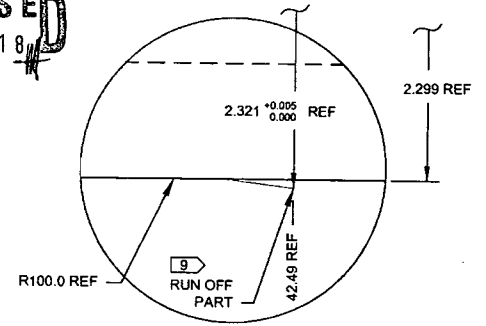
RELEASED
2011-01-18



DETAIL C:
CROSTUBE CUFF C8-4
SCALE 3X



DETAIL E:
CUFF TRANSITION A5-4
NOT TO SCALE



DETAIL D:
TAPER RUN-OFF C3-4
NOT TO SCALE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	90	D350-748-241	SHEET 4 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REMEASURE AFTER HEAT-TREAT & SANDBLAST

DART AEROSPACE LTD		Work Order: 83289
Description: Crosstube Assembly (AS350/355 High Aft)		Part Number: D350-748-241
Inspection Dwg: D350-748-241 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.230	✓	✓	VERN	CNC -08
	2.180	+0.005/-0.000	2.180	✓			
	2.180	+0.005/-0.000	2.181	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.236	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.269	✓			
	2.299	+0.005/-0.000	2.297	✓			
	0.063	+/-0.010	.063	✓		RL	
	4.26	+/-0.030	4.26	✓			
	R0.063	+/-0.010	.063	✓		RL	
	R0.50	+/-0.030	.50	✓		RL	
SIDE B	2.240	+0.005/-0.000	2.243	✓		VERN	CNC 08
	2.180	+0.005/-0.000	2.180	✓			
	2.180	+0.005/-0.000	2.175	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.230	✓			
	2.253	+0.005/-0.000	2.248	✓			
	2.272	+0.005/-0.000	2.274	✓			
	2.299	+0.005/-0.000	2.293	✓			
	0.063	+/-0.010	.063	✓		RL	
	4.26	+/-0.030	4.26	✓			
	R0.063	+/-0.010	.063	✓		RL	
	R0.50	+/-0.030	.50	✓		RL	
	122.70	+/-0.060	122.70	✓		TAPE	MM-02

Measured by: KC	Audited by:	Preliminary Approval:
Date: 12-6-06	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	
B	12.02.02	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

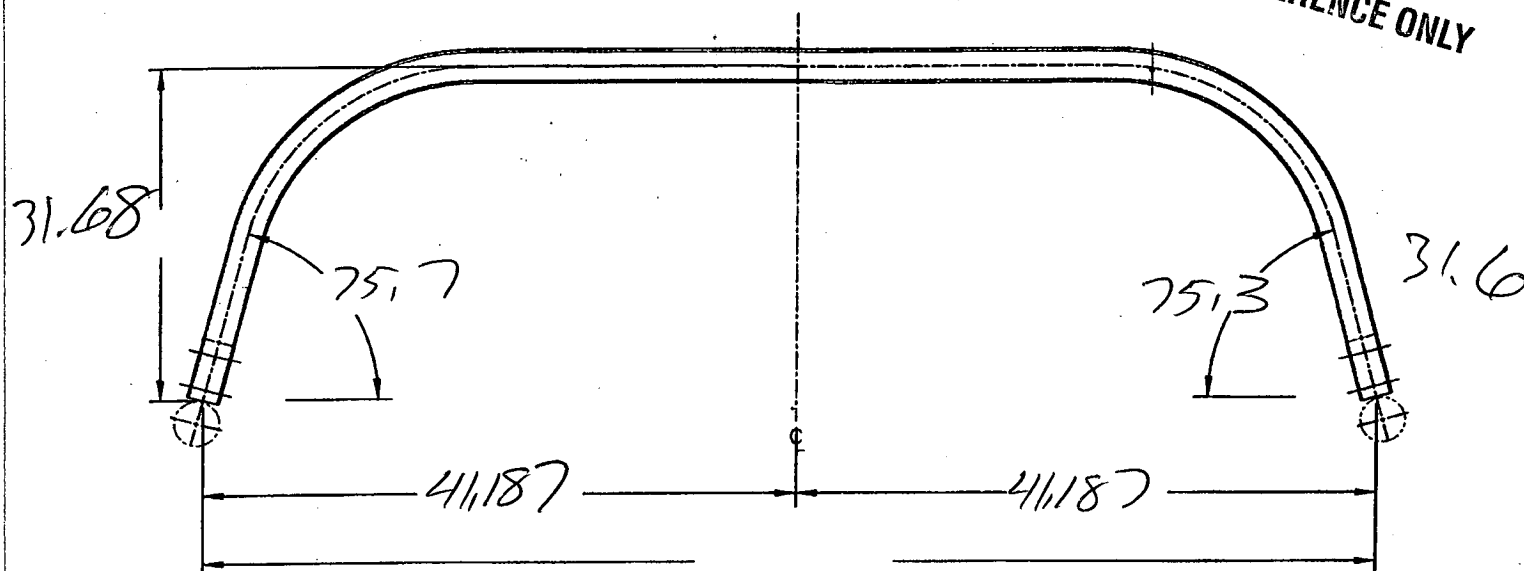
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 85335
Description: Crosstube High Aft (AS350/355)		Part Number: D350-748-201
Inspection Dwg: D350-748-241	Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06

REFERENCE ONLY



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	<i>[Signature]</i>

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Recu de Livraison

Order	Shipper	Shipping Seq.
176670	1	61651

Shipped Complete

Customer **215**

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Shipped To:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
PO17159		Steel	2012/6/7	PICK UP
Quantity	Part No. / Part Name / Part Description			Pounds
5	D350-748-301 CONTENANT: 1 PALETTE			150,

Container Type	# Of Containers	Container Comments
PALETTE	1	

CERTIFICAT

PACKING	
----------------	--

Quantity Shipped: 5
Pounds Shipped: 150,00
Quantity Remaining: 0
Pounds Remaining: 0,00

CERTIFICAT

Quantity Shipped: 5

Pounds Shipped: 150,00

Signature:

Date:

Shipped ON: 2012/06/08

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
176670	1

CLIENT / customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO17159		Steel		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

STRESS REL

SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
Visual			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
5	150	D350-748-201 (1) CROSSTUBE REFERENCE: 73806 (1) D350-748-201 CROSSTUBE REFERENCE: 73808 (1) D350-748-201 CROSSTUBE REFERENCE: 73809 (1) D350-748-201 CROSSTUBE REFERENCE: 85335 (1) D350-748-201 CROSSTUBE REFERENCE: 85402 CONTENANT: 1 PALETTE

Operation	Temp. spécifiée Specified Temp	Temps de trempé Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
176670	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN ---

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

Operation	Temp. spécifiée Specified Temp	Temps de trempé Spécifié Specified Soak Temp	Atmosphere	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
2.00 COMPTAGE PREPARING										
3.00 STRESS RE	343 +/-25°C	2:30 hrs	air			701				
4.00 FINAL INSP							06-08-2012			06-08-2012

COMMENTAIRES / comments

ALL THE HEAT TREATMENT PROCESSING PERFORMED ON THIS ORDER WAS ACCOMPLISHED USING HEAT TREATMENT EQUIPMENT THAT MEETS THE REQUIREMENTS OF AMS 2759. ALL THE HEAT TREATMENT OPERATIONS WERE ACCOMPLISHED IN ACCORDANCE WITH THE REQUESTED/REQUIRED HEAT TREATMENT SPECIFICATION AND ALL REQUIRED VERIFICATIONS TEST HAVE BEEN PERFORMED AND DOCUMENTED. NO UNAUTHORIZED CHANGES OR DEVIATIONS TO REQUIRED HEAT TREATMENT SPECIFICATIONS OR PROCEDURES HAVE BEEN PERFORMED.

APPROUVÉ par / Approved by:

[Signature]



DATE: 2012-06-08

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client./We certify that all the information on this report is exact and in accordance with the order requirements.

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jun-20-2012

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 115263
INVOICE #: 60974

**CONTRACT OR
PURCHASE ORDER #** PO17184

DESCRIPTION: CROSSTUBE

QTY 1

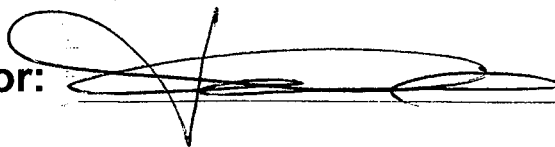
P/N # D350-748-201

S/N # 85335

STRESS RELIEF BAKE HEAT CHART # 12-589. MPI IAW ASTM-E-1444. CADMIUM PLATE IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART #12-604. MPI IAW ASTM-E-1444.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.11.01	161	LOAD TUBE TO 3000 ^{lb} FOR 1 MINUTE REF D.S. EMAIL		JP 12/6/21		JP 12/6/21	
11.11.01	162	NDT Tube					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 12189

CLIENT DART AERO SPACE DATE JUNE 27/2012 PAGE 1 OF 1
ATTENTION LINDA / MATT ACUREN JOB NO. 188-12-CO270 TIME AM ☒ PM ☐
ADDRESS 1270 ABERDEEN ST. PO/WO No. —
HAWKESBURY, ON. WORK LOCATION LINE
ACCEPTANCE STD. ASTM 1417/PSI-038 REV./DATE 2005
PROJECT F.P.I. on cross tubes
ITEM(S) EXAMINED 9 PCS

JOB DESCRIPTION PROCEDURE No. LT 0002 REV./DATE 2008 TECHNIQUE No. LT 1417 REV./DATE 2008
PART NO. SEE RESULTS MATERIAL STEEL/ALUMINUM THICKNESS VARIOUS
SCOPE A DYE FLOUORESCENT PENETRANT INSPECTION WAS CARRIED OUT ON THE EXTERNAL SURFACE 100%

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 18459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZL67 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. OTHER LABINO
DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE JULY 28/2012
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

ITEM	W.O. #	COMMENTS	ACCEPT	REJECT
1	85335	" "	✓	
1	73809	" "	✓	
1	85402	" "	✓	
1	73808	" "	✓	
1	73806	" "	✓	
1	84184	" "	✓	
1	84185	" "	✓	
1	84527	" "	✓	
1	84526	" "	✓	

STEEL TUBES
ALUMINUM TUBES

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Andy Sheldon PRINT Alsheldon SIGNATURE DTR # E-63661
TECHNICIAN (SIGNATURE): Mike Harsh REPORT REVIEWED BY:
NAME (PRINT): 1st TECHNICIAN NAME INITIALS
CGSB LEVEL II SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. No 6606 CGSB REG. No —

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

